

1 What is claimed is:

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3 1. In a blown film extrusion apparatus in which film is extruded as a tube from
4 an annular die and then pulled along a predetermined path, an apparatus for startup
5 of said extruded film tube, comprising:

6
7 (a) means for varying a quantity of air within said extruded film tube,
8 including:

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10 (1) a supply blower which supplies air to said extruded film tube in
11 an amount corresponding to a supply control signal, and

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13 (2) an exhaust blower which exhausts air from said extruded film
14 tube in an amount corresponding to an exhaust control signal;
15 and

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17 (b) a controller member including executable program instructions which
18 define at least one control routine for automatic and coordinated
19 control of said means for varying during starting of said extruded film
20 tube by directing a series of supply control signals to said supply
21 blower and exhaust control signals to said exhaust blower.

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1 2. An apparatus according to Claim 1, further comprising:

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3 (c) a control interface for receiving operator instructions during startup of
4 said extruded film tube; and

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6 (d) wherein said controller further includes program instructions for
7 receiving said operator instructions and integrating said operator
8 instructions into said at least one control routine.

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13 3. An apparatus according to Claim 1, wherein said at least control routine
14 comprises at least one of the following routines:

15
16 (a) a startup routine wherein said controller member initiates operation of
17 said supply blower and said exhaust blower by first initiating operation
18 of said supply blower in accordance with at least one predetermined
19 operating parameter, and then initiating said exhaust blower in accor-
20 dance with at least one predetermined operating parameter; and

21
22 (b) a blower optimization routine wherein at least one of (1) said supply
23 control signal, and (2) said exhaust control signal is determined at
24 least in part from at least one prior recorded control signal.
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1 4. An apparatus according to Claim 3, wherein said startup routine includes
2 executable program instructions for:

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4 (1) initially increasing air supplied by said supply blower to said extruded
5 film tube in accordance with a predetermined ramping function until
6 said extruded film tube is substantially closed; and

7
8 (2) then increasing air exhausted by said exhaust blower from said
9 extruded film tube in accordance with a predetermined ramping
10 function.

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14 5. An apparatus according to Claim 4, wherein said startup routine further
15 includes executable program instructions for:

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17 (3) continued increasing operation of at least one of said supply blower
18 and said exhaust blower in accordance with at least one predeter-
19 mined function.
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6. An apparatus according to Claim 1, further comprising:

- (c) a valve member, under control of said controller member, for varying admission of air into said extruded film tube and for controlling the circumference of said extruded film tube after startup of said extruded film tube.

7. An apparatus according to Claim 6, wherein said at least one control routine comprises at least one of the following routines:

- (a) a startup routine wherein said controller member initiates operation of said supply blower and said exhaust blower by first initiating operation of said supply blower in accordance with at least one predetermined operating parameter, and then initiating said exhaust blower in accordance with at least one predetermined operating parameter; and
- (b) a blower optimization routine wherein at least one of (1) said supply control signal, and (2) said exhaust control signal is determined at least in part from at least one prior recorded control signal; and
- (c) a valve optimization routine wherein an operating condition is established for at least one of (1) said supply blower, and (2) said exhaust blower in a manner which optimizes operation of said valve member.

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1 8. An apparatus according to Claim 7, wherein, during said valve optimization
2 routine, operating conditions are established for at least one of (1) said supply
3 blower, and (2) said exhaust blower, in order to allow said valve member to operate
4 in a preferred and substantially linear range of closure conditions.

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8 9. An apparatus according to Claim 1, further comprising:

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10 (c) at least one transducer for producing a signal corresponding to a
11 detected position of said extruded film tube;

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13 (d) wherein said at least one control routine includes:

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15 (1) a bubble break detection routine wherein said signal generated
16 by said at least one transducer is utilized in combination with at
17 least one software timer in order to detect a break in said
18 extruded film tube.

- 1 10. An apparatus for extruding a film tube, comprising:
2
3 (a) a die member;
4
5 (b) means for supplying molten film to said die member;
6
7 (c) a supply blower for supplying air to said extruded film tube in an
8 amount corresponding to a supply control signal;
9
10 (d) an exhaust blower for exhausting air from said extruded film tube in an
11 amount corresponding to an exhaust control signal;
12
13 (e) a valve for controlling air flow from said supply blower to said die
14 member in response to a valve control signal;
15
16 (f) a position sensor for providing a signal indicative of the size of said
17 extruded film tube;
18
19 (g) A controller member including executable instructions which define at
20 least one control routine;
21
22 (h) a control interface for receiving operator instructions; and
23
24 (i) said at least one control routine including:
25
26 a startup routine for automatic and coordinated control of
27 said supply blower and said exhaust blower during start-
28 up of said extruded film tube.
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1 11. An apparatus according to Claim 10, wherein said at least one control routine
2 includes:

- 3
- 4 (1) a startup routine wherein said controller member initiates operation of
5 said supply blower and said exhaust blower by first initiating operation
6 of said supply blower in accordance with at least one predetermined
7 operating parameter, and then initiating operation of said exhaust
8 blower in accordance with at least one predetermined operating
9 parameter; and
- 10
- 11 (2) a blower optimization routine wherein at least one of (a) said supply
12 control signal, and (b) said exhaust control signal is determined at
13 least in part from at least one prior recorded control signal.
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18 12. An apparatus according to Claim 11, wherein said startup routine includes
19 executable program instructions for:

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- 21 (a) initially increasing air supplied by said supply blower to said extruded
22 film tube in accordance with a predetermined ramping function until
23 said extruded film tube is substantially closed; and
- 24
- 25 (b) then increasing air exhausted by said exhaust blower from said
26 extruded film tube in accordance with a predetermined ramping
27 function.
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1 13. An apparatus according to Claim 12, wherein said startup routine includes
2 executable program instructions for:

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4 (c) continued increasing operation of at least one of said supply blower
5 and said exhaust blower in accordance with at least one predeter-
6 mined function.

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10 14. An apparatus according to Claim 11, wherein said at least one control routine
11 further includes:

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13 (3) a valve optimization routine wherein an operating condition is estab-
14 lished for at least one of (a) said supply blower, and (b) said exhaust
15 blower in a manner which optimizes operation of said valve member.

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19 15. An apparatus according to Claim 14 wherein, during said valve optimization
20 routine, operating conditions are established for at least one of (1) said supply
21 blower, and (2) said exhaust blower, in order to allow said valve member to operate
22 in a preferred and substantially linear range of closure conditions.

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26 16. An apparatus according to Claim 11, wherein said at least one control routine
27 further includes:

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29 (3) a bubble break detection routine wherein said signal generated by said
30 position sensor is utilized in combination with at least one software timer in order to
31 detect a break in said extruded film tube.

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1 17. A method of startup of an extruded film tube in a blown film extrusion
2 apparatus, comprising:

3
4 (a) providing a controller, a supply blower, and an exhaust blower;

5
6 (b) utilizing said supply blower to supply air to said extruded film tube in
7 an amount corresponding to a supply control signal;

8
9 (c) utilizing said exhaust blower to exhaust air from said extruded film tube
10 in an amount corresponding to an exhaust control signal; and

11
12 (d) utilizing said controller member for executing program instructions
13 which define at least one control routine for automatic and coordinated
14 control during starting of said extruded film tube by directing a series
15 of supply control signals to said supply blower and exhaust control
16 signals to said exhaust blower.

1 18. A method according to Claim 17, further comprising:

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- 3 (e) providing a control interface for receiving operator instructions during
- 4 startup of said extruded film tube; and
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- 6 (f) wherein said controller further executes program instructions for
- 7 receiving said operator instructions and integrating said operator
- 8 instructions into said at least one control routine.
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13 19. A method according to Claim 17, further comprising:

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- 15 (e) utilizing said controller to execute program instructions of a startup
- 16 routine wherein said controller member initiates operation of said
- 17 supply blower and said exhaust blower by first initiating operation of
- 18 said supply blower in accordance with at least one predetermined
- 19 operating parameter, and then initiating said exhaust blower in accor-
- 20 dance with at least one predetermined operating parameter; and
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- 22 (f) utilizing said controller to execute program instructions of a blower
- 23 optimization routine wherein at least one of (1) said supply control
- 24 signal, and (2) said exhaust control signal is determined at least in part
- 25 from at least one prior recorded control signal.
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1 20. A method according to Claim 19, wherein said startup routine includes
2 executable program instructions for:

3
4 (1) initially increasing air supplied by said supply blower to said extruded
5 film tube in accordance with a predetermined ramping function until
6 said extruded film tube is substantially closed; and

7
8 (2) then increasing air exhausted by said exhaust blower from said
9 extruded film tube in accordance with a predetermined ramping
10 function.

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14 21. A method according to Claim 20, wherein said startup routine further includes
15 executable program instructions for:

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17 (3) continued increasing operation of at least one of said supply blower
18 and said exhaust blower in accordance with at least one predeter-
19 mined function.
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1 22. A method according to Claim 17, further comprising:

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- 3 (e) providing a valve member, under control of said controller member, for
- 4 varying admission of air into said extruded film tube and for controlling
- 5 the circumference of said extruded film tube after startup of said
- 6 extruded film tube.
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10 23. A method according to Claim 22, wherein said at least one control routine

11 comprises at least one of the following routines:

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- 13 (1) a startup routine wherein said controller member initiates operation of
- 14 said supply blower and said exhaust blower by first initiating operation
- 15 of said supply blower in accordance with at least one predetermined
- 16 operating parameter, and then initiating said exhaust blower in accor-
- 17 dance with at least one predetermined operating parameter; and
- 18
- 19 (2) a blower optimization routine wherein at least one of (1) said supply
- 20 control signal, and (2) said exhaust control signal is determined at
- 21 least in part from at least one prior recorded control signal; and
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- 23 (3) a valve optimization routine wherein an operating condition is estab-
- 24 lished for at least one of (1) said supply blower, and (2) said exhaust
- 25 blower in a manner which optimizes operation of said valve member.
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1 24. A method according to Claim 23, wherein, during said valve optimization
2 routine, operating conditions are established for at least one of (1) said supply
3 blower, and (2) said exhaust blower, in order to allow said valve member to operate
4 in a preferred and substantially linear range of closure conditions.
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9 25. A method according to Claim 17, further comprising:
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- 11 (e) providing at least one transducer for producing a signal corresponding
12 to a detected position of said extruded film tube;
13
14 (f) wherein said at least one control routine includes a bubble break
15 detection routine wherein said signal generated by said at least one
16 transducer is utilized in combination with at least one software timer in
17 order to detect a break in said extruded film tube.

26. An improved blown film extrusion apparatus, comprising:

- (a) a die for receiving molten material and extruding a film tube;
- (b) a controller member;
- (c) a supply blower which is responsive to command signals from said controller for supplying a variable quantity of air to said film tube;
- (d) an airflow path between said supply blower and said die;
- (e) an exhaust blower which is responsive to command signals from said controller for exhausting a variable quantity of air from said film tube;
- (f) an air flow control member which is at least in-part responsive to command signals from said controller member for varying a quantity of air passing within said air flow path, and which includes:
 - (1) a housing with an inlet, an outlet, and an air path defined there-through;
 - (2) at least one selectively-expandable flow restriction member disposed in said housing in said air flow path; and
 - (3) wherein said air flow member selectively expands and reduces said at least one selectively-expandable flow restriction member to moderate air flow through said air flow path.
- (g) at least one program routine executable by said controller member which optimizes operation of said supply blower, said exhaust blower, and said air flow control member.

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1 27. An improved blown film apparatus according to Claim 26:

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3 (h) wherein said at least one selectively-expandable flow restriction
4 member includes a bladder member which selectively communicates
5 with a control fluid; and

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7 (i) wherein application of said control fluid to said at least one selectively-
8 expandable flow restriction member causes expansion and reduction
9 of said at least one selectively-expandable flow restriction member.

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14 28. An improved blown film apparatus according to Claim 26, wherein said air
15 flow control member includes:

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17 (1) a plurality of housings, each having an inlet, outlet, and an air flow
18 path defined therethrough;

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20 (2) a plurality of selectively-expandable flow restriction members disposed
21 in each of said housings; and

22
23 (3) with each flow path through said plurality of housings in at least one
24 of (a) series, and (b) parallel communication with said selected others
25 of said air flow paths.

1 29. An improved blown film apparatus, according to Claim 26, wherein:

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3 (h) expansion of said at least one selectively-expandable flow restriction
4 member restricts said air path defined through said housing; and

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6 (i) reduction of said at least one selectively-expandable flow restriction
7 member expands said air path defined through said housing.
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